

Date: Wednesday, 12/7/2005 12:45:34 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LOCK SHAFT R44
<b>Job Number</b> : 25169	
<b>Estimate Number</b> : 11268	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D33575
<b>This Issue</b> : 12/7/2005 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D3357 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> : <i>N/A</i>	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>SEE COMMENT BELOW</i>	<b>Due Date</b> : 1/10/2006 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>SEE COMMENT BELOW</i>	
<b>Comment</b> : Est Rev:A 05.09.13 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M174R1000	17-4PH SS ROUND BAR 1.00
-----	-----------	--------------------------



**Comment:** Qty.: 0.4194 f(s)/Unit Total : 4.1937 f(s)  
 17-4PH SS ROUND BAR 1.00  
 (M174R0100)  
 Batch: *M19430*

*ml 06/01/31* 10

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA505 and Dwg D3357

2-Deburr

*ml 06/02/01* 10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*ml 06/02/01* 10

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Mill as per Dwg D3357

*ml 06/02/05* 10

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*ml 06/02/05* 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 06/07

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 12:45:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOCK SHAFT R44

Job Number: 25169

Part Number: D33575

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MB 06/02/05 10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 419

CX 06/02/06 10

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/07 (10) 06/02/07 (10)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

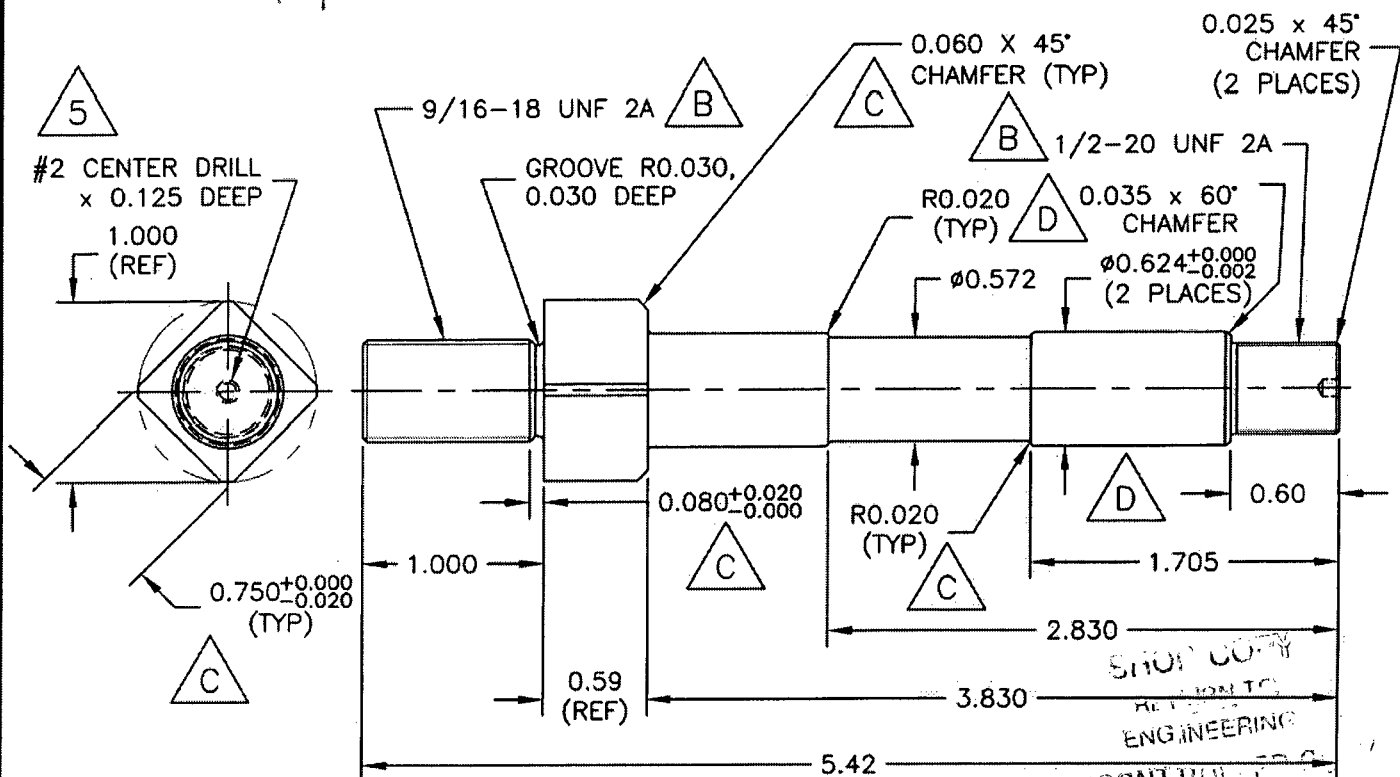


**DART**

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED	DRAWING NO. D3357	REV. D SHEET 1 OF 3
DATE 05.12.02		TITLE SHAFTS	SCALE 1:1
A	04.12.13	NEW ISSUE	
B	05.05.27	ADD THREAD SPEC & 0.063; 17-4 PH ROUND WAS 303 HEX SS	
C	05.07.21	0.750 WAS 0625; 0.100 WAS 0.063	
D	05.12.02	Ø0.624 WAS Ø0.623; 0.60 WAS 0.71	

**RELEASED**

05/12/02

**D3357-1 R22/R44 WHEEL SHAFT****NOTES:**

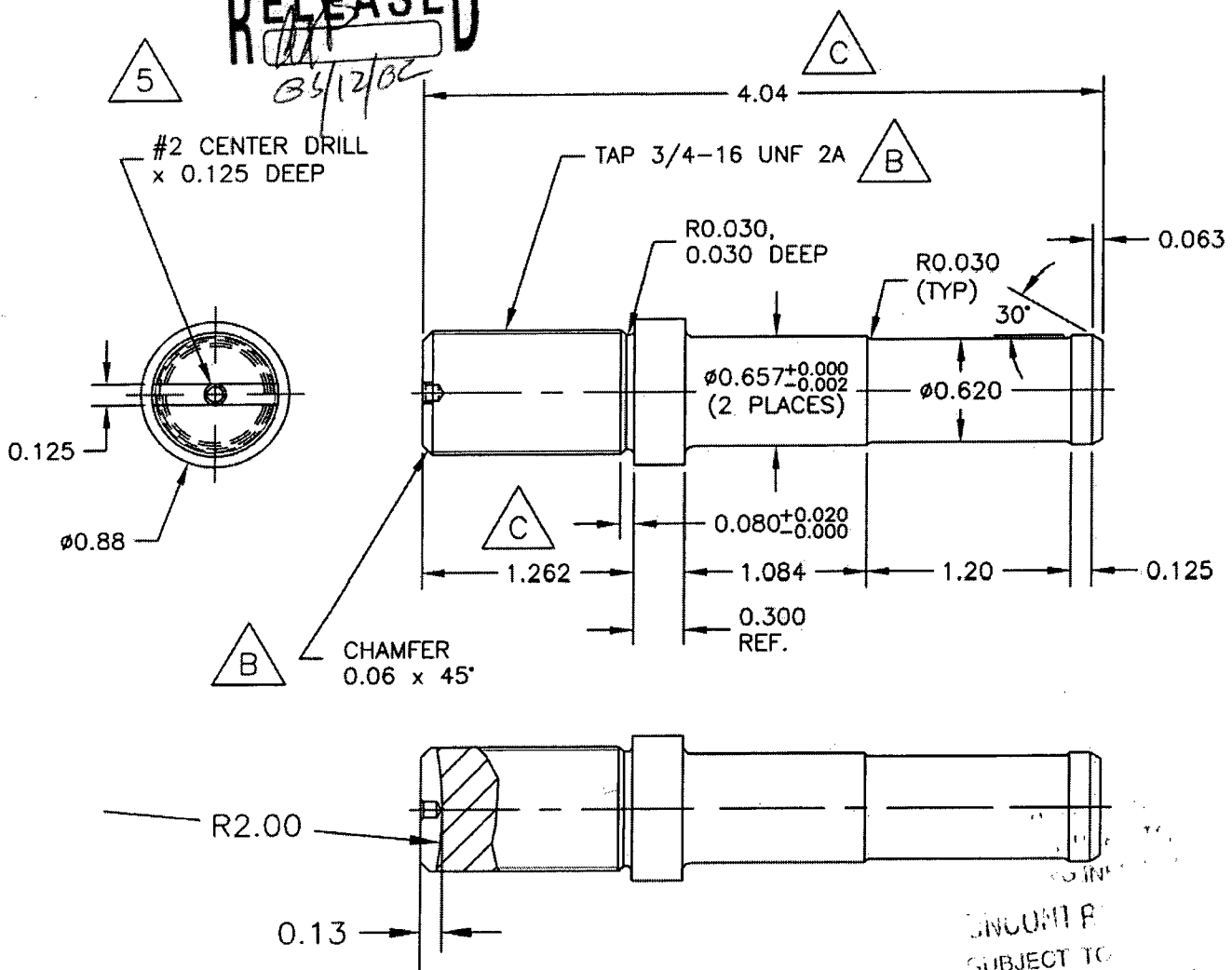
- 1) MATERIAL: 17-4 PH ROUND BAR STAINLESS STEEL CONDITION H900 (REF. DART SPEC. M17-4-R1.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) CENTER DRILL AS REQUIRED

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**DART**

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3357	REV. D SHEET 2 OF 3
DATE 05.12.02		TITLE SHAFTS	SCALE 1:1

**D3357-3 R22 LOCK SHAFT****NOTES:**

- 1) MATERIAL: 17-4 PH ROUND BAR STAINLESS STEEL CONDITION H900 (REF. DART SPEC. M17-4-R1.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) CENTER DRILL AS REQUIRED

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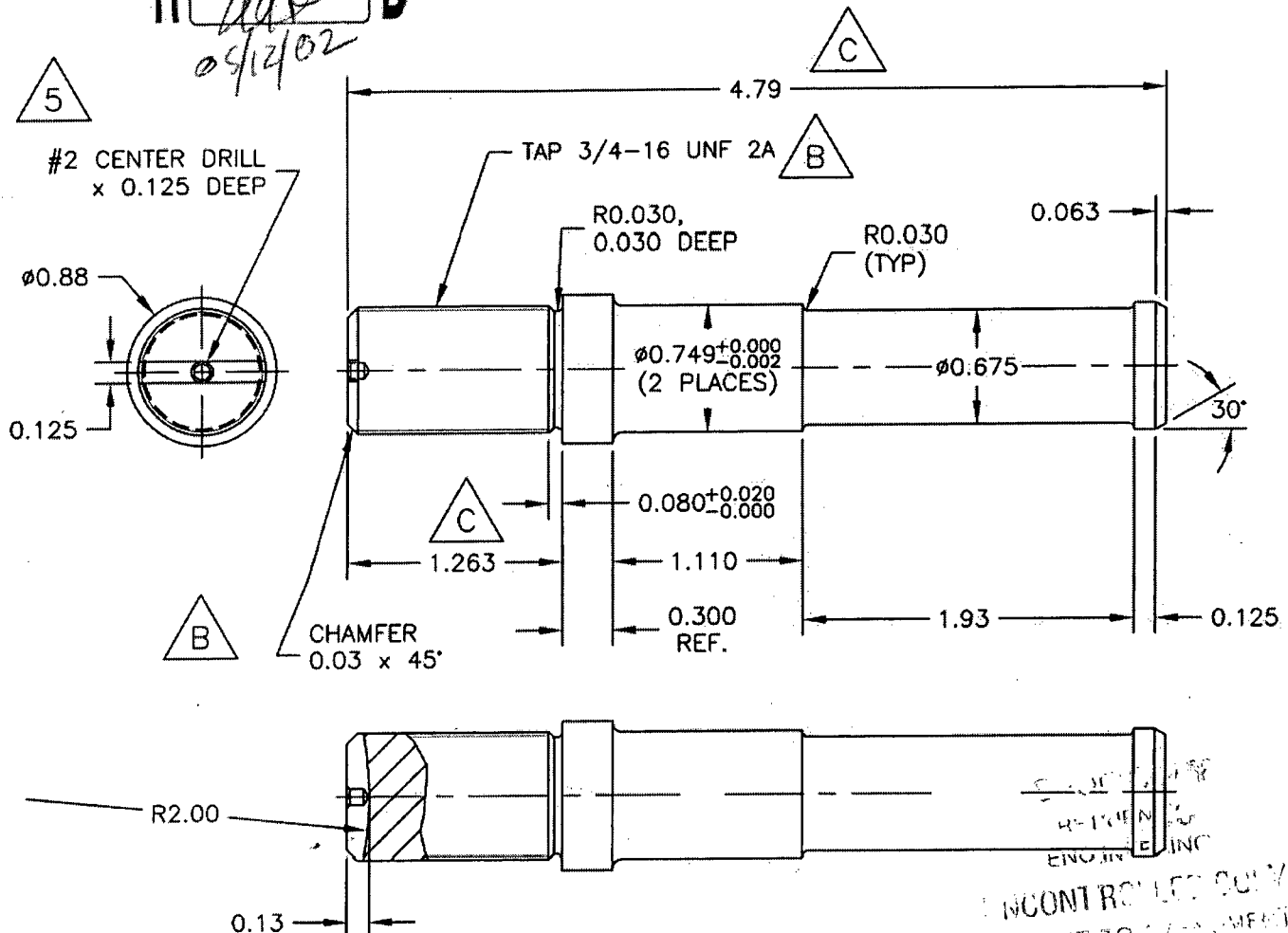
WORK ORDER  
NO 25169

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**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3357	REV. D SHEET 3 OF 3
DATE 05.12.02	TITLE SHAFTS		SCALE 1:1

**RELEASED**  
*[Signature]*  
05/24/02**D3357-5 R44 LOCK SHAFT****NOTES:**

- 1) MATERIAL: 17-4 PH ROUND BAR STAINLESS STEEL CONDITION H900  
(REF. DART SPEC. M17-4-R1.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) CENTER DRILL AS REQUIRED

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